

5/17/2018

[Dart Hawkesbury] Job Sheet - David, Logan



006553

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM652V3002101-M-35
Job Sheet 177788



23 NOV

Part No: RBEM652V3002101-M-35

Job Qty: 6 ea 21

Part Name: Lid Assembly

3-89



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/17/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM652V3002101-M Rev D IPP Rev A 18.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	6 pcs	8/6/18	8/6/18	0.00	6.00	Small Fab-3		MLL DAS
120	QC	6 pcs	8/6/18	8/6/18	0.00	0.00	QC5		38
130	Packaging	6 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-1		DAS MLL 9-89
140	QC21-SA	6 Ea	8/6/18	8/6/18	0.00	0.00	QC21		21 NOV 20 17

Part Op 110 - 1-Assemble as per DWG. Sheet 5. 2-Install item -48 hand tight 3-Align dowel pin hole then apply clear multi purpose
Descriptions: Loctite to mating surfaces of item -27 and -9. Press fit together and immediately install dowel pin. -Loctite 263

B M138904 Exp.: 4/20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98380A473	Dowel Pin	6 Ea (1 ea)	90-Start up Operation	5075951
99908A102	Flande Locknut, Steel	18 Ea (3 ea)	90-Start up Operation	5075953
RBEM652V3002101-M-27	Stud	6 Ea (1 ea)	90-Start up Operation	3123078
RBEM652V3002101-M-31	Cap	6 Ea (1 ea)	90-Start up Operation	3126001
RBEM652V3002101-M-39	Plate Assembly	6 pcs (1 ea)	90-Start up Operation	5120604
RBEM652V3002101-M-41	Foot Assembly	6 Ea (1 ea)	90-Start up Operation	5124375
RBEM652V3002101-M-7	Stud	12 Ea (2 ea)	90-Start up Operation	5107317
RBEM652V3002101-M-9	Bar Handle Nut	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98380A473	6	0	0
	99908A102	18	0	0
	RBEM652V3002101-M-27	6	0	0
	RBEM652V3002101-M-31	6	0	0
	RBEM652V3002101-M-39	6	0	0
	RBEM652V3002101-M-41	6	0	0
	RBEM652V3002101-M-7	12	0	0
	RBEM652V3002101-M-9	6	0	0



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not be found.

Container No: S129428



Part: RBEM652V3002101-M-35

Job No: 177788

Serial No/Batch: S129428

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 11/20/18

Plex 5/17/18 3:24 PM dart.logan.david

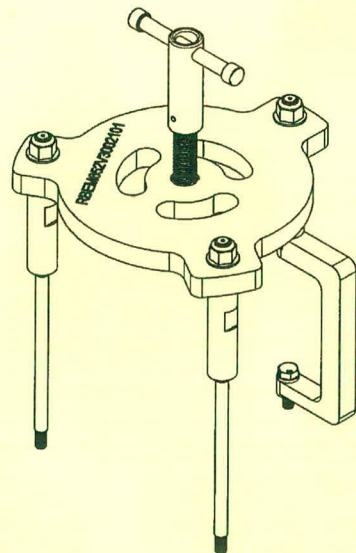
140

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104

ITEM #	QTY	PART #	PART TITLE
-7	2	RBEM652V3002101-M-7	STUD
-9	1	RBEM652V3002101-M-9	BAR HANDLE NUT
-27	1	RBEM652V3002101-27	STUD
-31	1	RBEM652V3002101-M-31	CAP
-39	1	RBEM652V3002101-39	PLATE ASSY
-41	1	RBEM652V3002101-M-41	FOOT ASSY
48	3	McMaster#99908A102 OR EQUIV	FLANGE LOCKNUT STEEL M8 x 1.25mm CLASS 10
49	1	McMaster#98380A473 OR EQUIV	DOWEL PIN STEEL 1/8" DIA. x 3/4" LG.



RBEM652V3002101-M-35 LID ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

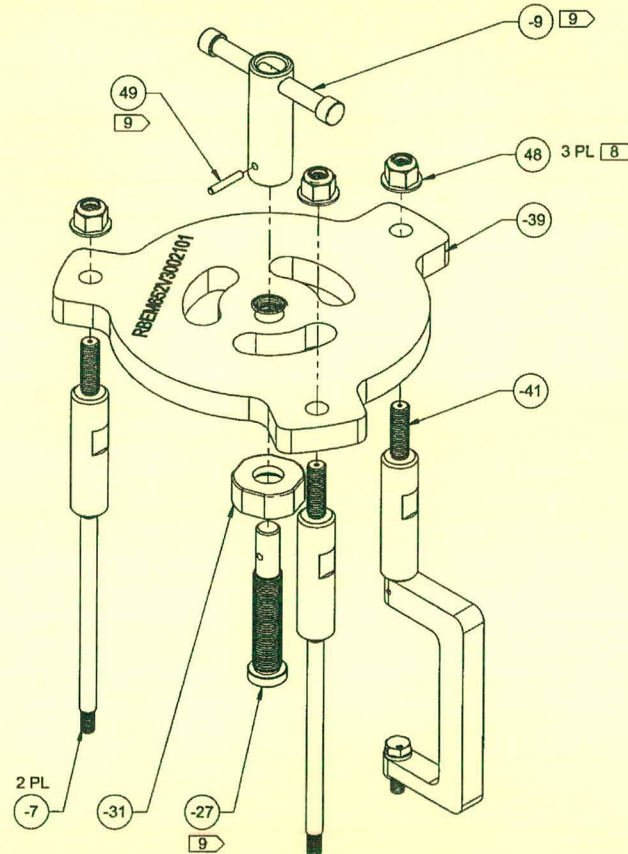
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

- 8) ASSEMBLE AS SHOWN, INSTALL ITEM 48 HAND TIGHT
- 9) ALIGN DOWEL PIN HOLE THEN APPLY CLEAR MULTIPURPOSE LOCTITE EPOXY ON MATING SURFACES OF ITEM -27 AND ITEM -9.

PRESS FIT TOGETHER. IMMEDIATELY INSTALL DOWEL PIN



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	REV. D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 5 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/28/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											